Work Order ID 103474

103474

June-24-13 1:56:24 PM

Item ID: D2654-5 **Accept** *N900040100* **Setup** **Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Web

Start Date: 7/16/13 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 7/16/13 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run **Start** *NR1* **Stop** *NR2*

Approvals: **Process Plan:** MLJ **Date:** 13-06-26 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2654	F

100 *100* Skidtubes Skidtubes

Skidtubes 0.00

Memo 0.00

1-Cut D2600-7 to length as per Dwg D2654
2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654
3-Using the uni-bit, open holes to finish size as per Dwg D2654
4-Deburr holes and ends

DL / SAD 13-7-9

110 *110* QC Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo 0.00

DAS 03 89 — DP 13-7-9 (4)

120 *120* HandFinish Hand Finishing

Chemical Conversion Coat per QSI005 4.1 0.00

Memo 0.00

DV / SAD 13-07-10

DQA: ________ Date: ________

QA Closed: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: ________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread		
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set		
☐ Turning Sequence	☐ Finish	☐ Out of Calibration		
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		

Work Order ID 103474 *103474*

June-24-13 1:56:24 PM

Item ID:	D2654-5	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Web	**Stop**	*NS2*
Start Date:	7/16/13	**Start Qty:** 4.00	*4*
Required Date:	7/16/13	**Req'd Qty:** 4.00	*4*
Reference:		**Cust Item ID:**	
		Customer:	

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run Start *NR1* **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC7-Inspect Chemical Conversion Coat	0.00				4		JB 13/02/11	
	Memo	0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: LG	0.00						JB 13/07/11	
	Memo	0.00							
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00						13/7/11	[signature]
	Memo	0.00							

[signature] 13-07-11

DQA: ________ Date: ________

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: ________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	________	
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	________	
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	________	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	________	

Picklist Print

June-24-13 1:56:24 PM

Work Order ID: **103474**

Parent Item: **D2654-5**

Parent Item Name: Web

Start Date: 7/16/13 **Required Date:** 7/16/13

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-7-140 EXT. "I BEAM" THICK		Manufactured	No			100	Each	80.0000	1	4			

Location	Loc Qty	Loc Code
HALL	80	
41591	1	
72279	79	

4 P.L 13-7-9

DQA: ____________ Date: ____________

QA Closed: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

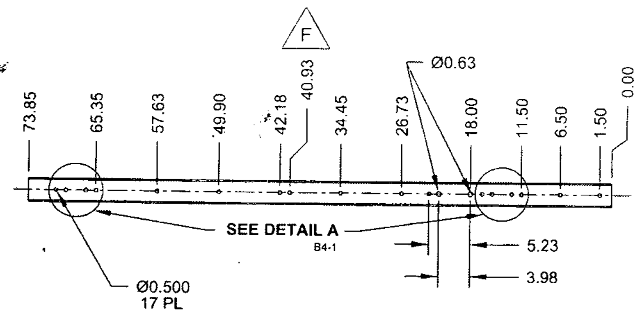
Work Order update only ☐

Work Order: ____ Part No. ____ NCR No. ____	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

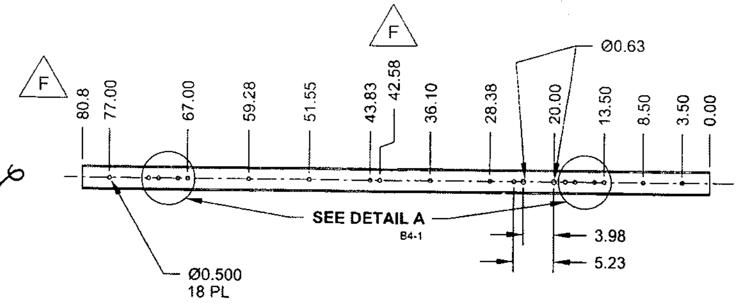
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

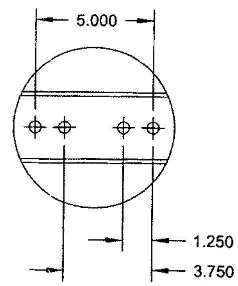
Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread		
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set		
☐ Turning Sequence	☐ Finish	☐ Out of Calibration		
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

103474
MCJ
13-06-26

RELEASED
2011-09-12

NOTES:
1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

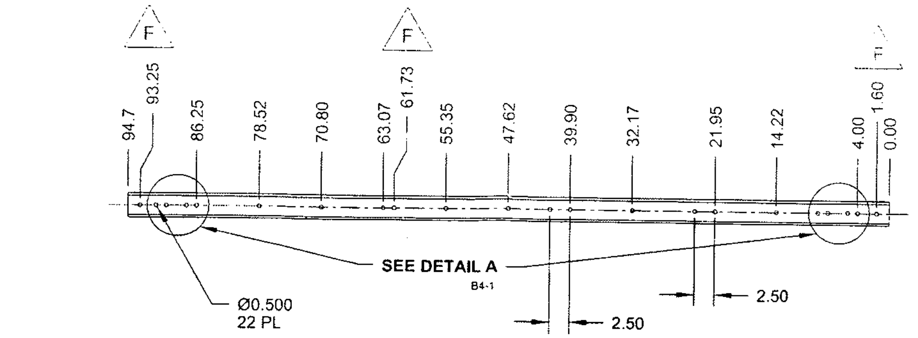
REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATERN	CP	97.10.29
B	ALTER HOLE PATERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25

DESIGN	CP
DRAWN	SC
CHECKED	[signature]
MFG. APPR.	[signature]
APPROVED	[signature]
DE APPR.	[signature]
DATE	11.05.05

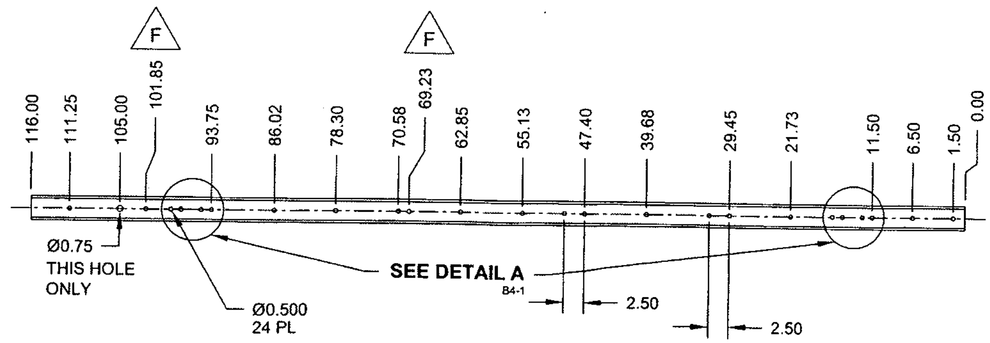
DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D2654 — REV. F — SHEET 1 OF 2
TITLE: WEB — SCALE: NTS

103474



D2654-5 WEB



D2654-7 WEB

RELEASED 2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	SC	
CHECKED	[signature]	DRAWING NO. D2654 — REV. F — SHEET 2 OF 2
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE WEB — SCALE NTS
DE APPR.	[signature]	
DATE	11.05.05	